

Tuesday, December 06, 2016 2:50:46 PM

Page 1

Stop ***NR2***

[illegible]

Work Order ID 154217

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154217

Page 2

Item ID: D3720-2

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Spacer

Start Date: 1/27/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 2/1/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run

Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.02							
Quality Control									DAS 38 9-89 DEC 12 2016
130	Small Fab	0.00							
130									
Small Fab	Memo	0.02							
Small Fab	C'sink as per dwg D3720								DAS 36 9-89 11/12/12
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.02							
Quality Control									DAS 38 9-89 DEC 12 2016

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Stop ***NR2***

LOCATION : GA

DEC 19 2016

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Page 4

Item ID: D3720-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Spacer
Start Date: 1/27/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 2/1/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.10							
Quality Control									

DAS
21
9-89 DEC 19 2016
MF
16-12-19

Picklist Print

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Page 1

Work Order ID: 154217

154217

Parent Item: D3720-2

D3720-2

Parent Item Name: Step Spacer

Start Date: 1/27/2017

Required Date: 2/1/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev :A New Issue 08-01-11 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased		No		110	sf	27.6900	0.085	0.536842			

M6061T6S 125

6061-T6 .125 Sheet

on 16/12/09

Location

Loc Qty

Loc Code

MAT020

27.69

m134696

0.01

m134982

5.12

m135377

4.85

m135860

17.71

 6

DQA: _____ Date: _____



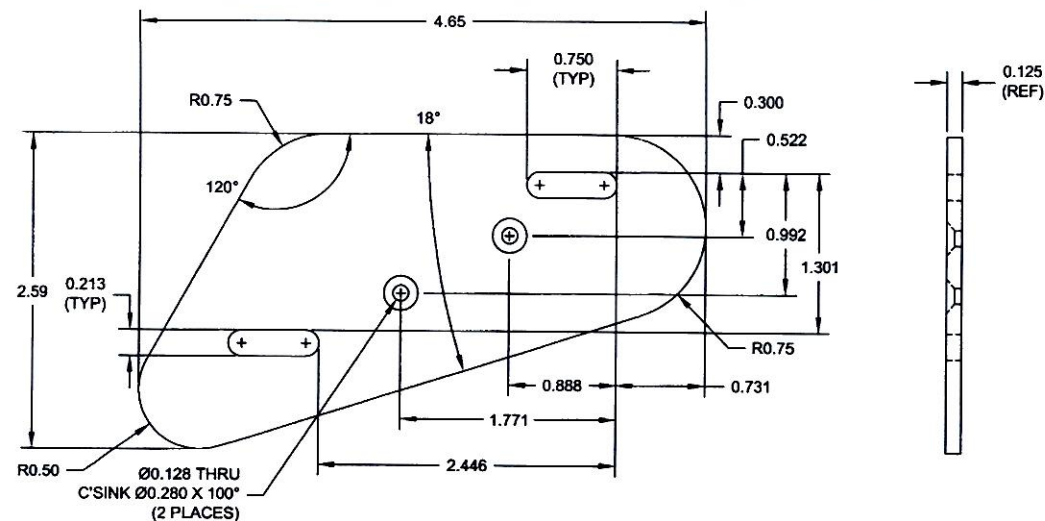
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

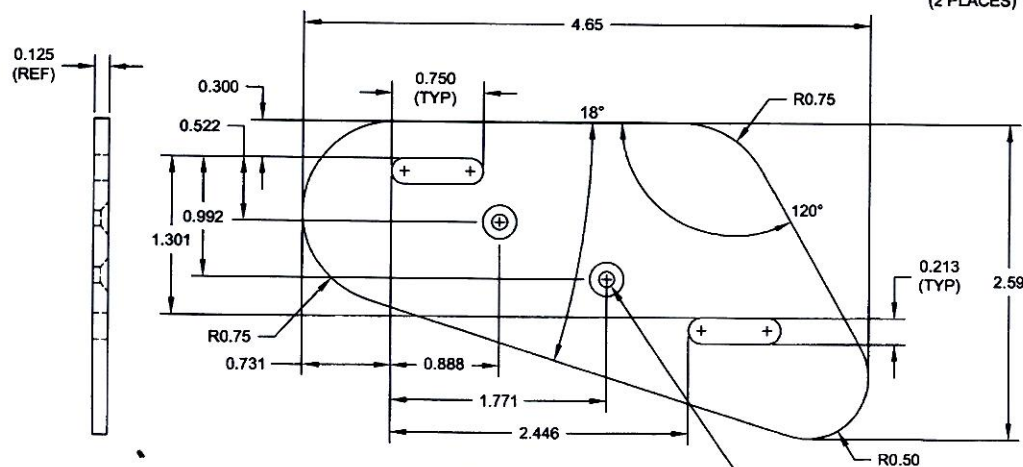
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																																
Description Work Order Deviation		Disposition		Completed By																																																																
				Lead hand / Supervisor Approval Verification																																																																
				QC / QA Coordinator Approval																																																																
Root Cause		FAULT CATEGORY																																																																		
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OTHER : _____																																																																				

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154217 MLS
16-12-07



D3720-1 STEP SPACER



D3720-2 STEP SPACER

NOTES:

- 1) MATERIAL: 6061-T6 (OR -T62) ALUMINUM SHEET 0.125 THICK (PER QQ-A-250/11 OR AMS 4025/4027) (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

RELEASED

A NEW ISSUE		PH	07.12.27
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	BE		
CHECKED	LS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.12.27		
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DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D3720
REV. A
SHEET 1 OF 1
TITLE STEP SPACER
SCALE 1:1